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RBT18560
Job Sheet 194180



Part No: RBT18560

Job Qty: 2 pcs

Part Name: Engine Gearbox Seal Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBT18560 Rev 4 IPP Rev A 17.11.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	6/14/19		0.00	2.00	Small Fab - 1		DAS 71 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	6/14/19		0.00	0.00	QC 5 - 10		19-5-13
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	2 pcs	6/14/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		

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Container No: S180871



Part: RBT18560

Job No: 194180

Serial No/Batch: S180871

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 05/13/19

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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	6/14/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

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9-55

Part Op 110 - (Small Fab) - Assemble as per DWG. Sheet 1
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container	
3408A94	Ball Plunger without thread locker	4 Ea (2 ea)	110-Small Fab - 1	5133293	203
90565A330	Tall Nut 1/2-20 UNF	2 Ea (1 ea)	110-Small Fab - 1	5031237	65
91255A542	Button Head Socket Cap Screw 5/16-20 UNC x 1	4 Ea (2 ea)	110-Small Fab - 1	5031238	203
94846A525	Jam Nut 1/2-20	2 Ea (1 ea)	110-Small Fab - 1	3031248	58
NTA-815	Thrust Bearing	2 Ea (1 ea)	110-Small Fab - 1	3033969	34
RBT18560-1	Puller	2 pcs (1 ea)	110-Small Fab - 1	5148267	145B
RBT18560-11	Upright	4 pcs (2 ea)	110-Small Fab - 1	5150283	145B
RBT18560-3	Ring	2 pcs (1 ea)	110-Small Fab - 1	5146814	u
RBT18560-5	Screw	2 pcs (1 ea)	110-Small Fab - 1	5148302	u
RBT18560-9	Cross Bar	2 pcs (1 ea)	110-Small Fab - 1	5151610	u
TRA-815	Bearing Washer	4 Ea (2 ea)	110-Small Fab - 1	5151600	36

5036194

nu. 0

nu. 1

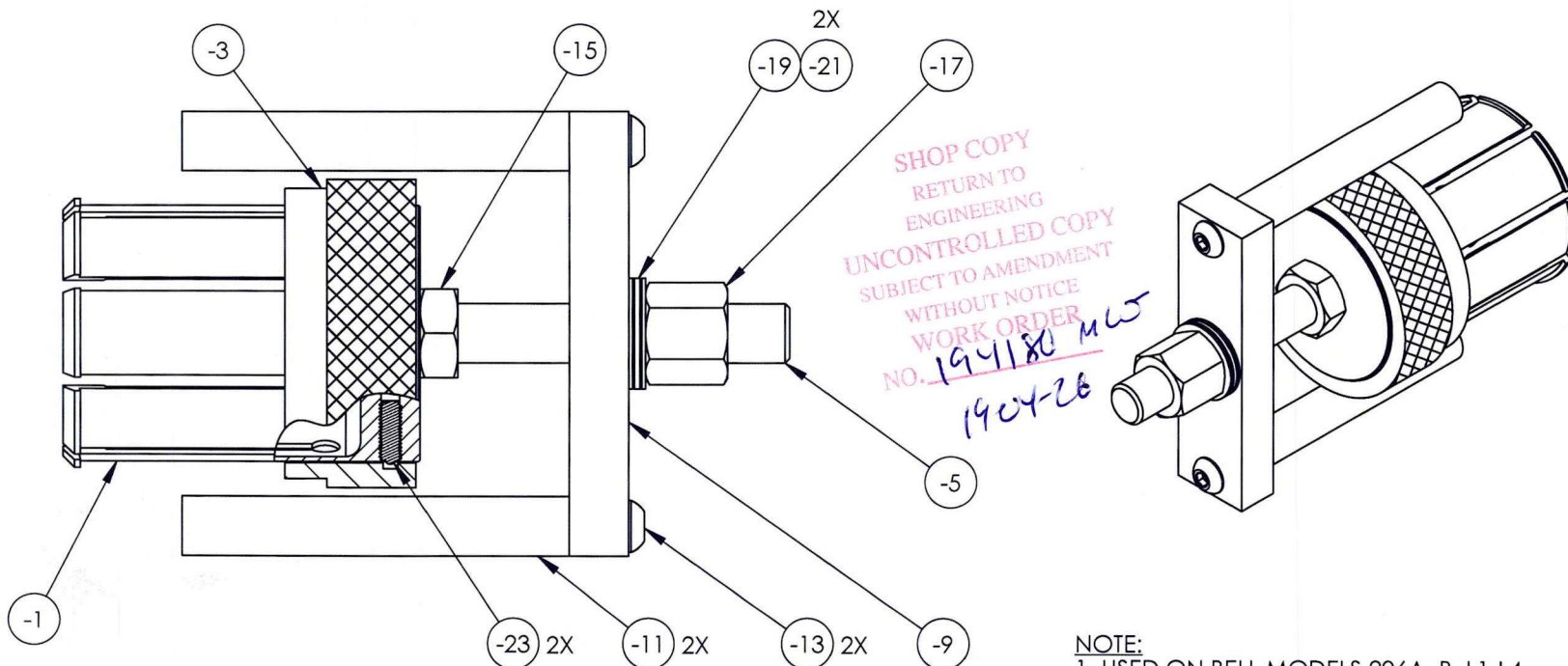
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3408A94	4	21	0
	90565A330	2	53	0
	91255A542	4	72	0
	94846A525	2	87	0
	NTA-815	2	19	0
	RBT18560-1	2	10	0
	RBT18560-11	4	17	0
	RBT18560-3	2	8	0
	RBT18560-5	2	14	0
	RBT18560-9	2	21	0
	TRA-815	4	36	0
Part Specifications				
Specifications could not be found.				

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TEO ATTACHED

REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
1		-1 PULLER SLOT HOLES INCREASED TO Ø1/4 & WALL THINNED FOR FLEXIBILITY, -3 RING SHORTENED & GROVE MOVED TO ALLOW -1 PULLER TEETH TO FULLY EXPAND, -7 ILLUMINATED, -9 CROSS BAR WIDTH INCREASED TO 1 FOR ADDED STRENGTH.	2/12/2003			
2		ADDED NEW BOM, TITLE BLOCK, & REV. TABLE, RE-ORGANIZED DWG.'S AND CORRECTED ERRORS. CREATED AN ASSEMBLY DWG, AND COMBINED TWO FILES.	11/20/2007	WP	RW	
3		CH'D -9 HOLE FROM Ø.250 (X2) TO Ø.257 (X2) SER S.E.	12/29/2011	RJC	SE	
4	15-0472	-9 CH'D ENGRAVE NOTE TO T/N, S/N, "MADE IN USA". UPDATED TO NEW DRAFTING STANDARDS.	1/5/2016	SM	JAG	



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PULLER	H13		2
			-3	1	RING	DOM		3
		B/O	-5	1	SCREW	STEEL	1/2-20 UNF X 4 IN THREADED ROD (MCMaster-CARR # 98750A483) MODIFIED	4
			-9	1	CROSS BAR	1018/1020 CR		5
			-11	2	UPRIGHT	1018/1020 CR		6
		B/O	-13	2	BTN-HEAD SKT CAP SCR	STEEL	1/4-20 UNC X 1 (MCMaster-CARR # 91255A542)	1
		B/O	-15	1	JAM NUT	STEEL	1/2-20 JAM NUT (MCMaster-CARR # 94846A525)	1
		B/O	-17	1	TALL NUT	STEEL	1/2-20 UNF (MCMaster-CARR # 90565A330)	1
		B/O	-19	1	THRUST BEARING	STEEL	APPLIED # NTA-815	1
		B/O	-21	2	BEARING WASHER	STEEL	APPLIED # TRA-815	1
		B/O	-23	2	BALL PLUNGER	S.S.	10-32 X 33/64 (MCMaster-CARR # 3408A94)	1

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560	REV 4
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/√
SPEC DRAWN BY: COLE CHECKED: DUERFELDT OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .016R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL SEE NOTE 1
SCALE 2:3	DATE 5/2/2002
SHEET 1 OF 6	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					